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D2281**Job Sheet 212591****Part No:** D2281**Job Qty:** 30 pcs**Part Name:** Jack Saddle**Part Weight:** 0 lbs**Status:** New**Priority:** Medium**Job Created:** 8/27/20**Job Tracking No:****Due Date:** 10/30/20**Created By:** Marie Lajeunesse**Type:** SOLD**Description:****Note:** DWG REV G IPP Rev:A Removed from 9 Digit 05-12-02 JLM IPP: rev B**Ship Via:****Bill of Materials****Job Routing**

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	30 pcs		10/29/20	0.17	1.57	Waterjet - Flow		on 20/09/23
120	QC 8	30 pcs		10/29/20	0.00	0.00	QC 8 - 12		
							QC 8 - 14		
							QC 8 - 17		
							QC 8 - 20		
							QC 8 - 25		
							QC 8 - 3		
							QC 8 - 32		
							QC 8 - 33		
							QC 8 - 35		
							QC 8 - 39		
							QC 8 - 4		
							QC 8 - 44		
							QC 8 - 45		
							QC 8 - 49		
							QC 8 - 58		
							QC 8 - 8		
							QC 8 - 9		
							QC 8 - 68		
							QC 8 - 67		
							QC 8 - 1 (A)		
							QC 8 - 47		
							QC 8 - 40		on 20/09/23
							QC 8 - 52		
							QC 8 - 23		
							QC 8 - 57		
							QC 8 - 76		
							QC 8 - 61		
							QC 8 - 66		
							QC 8 - 73		

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140	Small Fab - Brake NC - B4B	30 pcs	10/30/20	0.25 0.76	QC 8 - 82	
					Small Fab - Brake - 1 - B4B	
					Small Fab - Brake - 2 - B4B	
150	QC 5	30 pcs	10/30/20	0.00 0.00	Small Fab - Brake - 3 - B4B	SEP 28 2020
					QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	EL 9-27-20
					QC 5 - 30	
					QC 5 - 40	
					QC 5 - 61	
					QC 5 - 81	
					QC 5 - 82	
160	Packaging 3-1 - Stock - B4B	30 pcs	10/30/20	0.00 0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	EL 9-29-20
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	

170 QC 21 - SA	30 pcs	10/30/20	0.00 0.00	Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	DAS
				Packaging 3 - 37 - B4B	21
				QC 21 - SA - 21	9-00
				QC 21 - SA - 70	SEP 29 2020
				QC 21 - SA - 9	
				QC 21 - SA - 77	

Part Op 100 - 1-Cut as per Dwg Dwg Rev: G Prog Rev: G 2-Deburr if necessary
 Descriptions: 120 - (QC8- Inspect parts - second check)
 140 - Form as per D2281 using D2281-T2
 150 - (QC5- Inspect part completeness to step on W/O)
 160 - (Identify as per dwg & Stock Location:) LOCATION: WA001-1
 170 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304S14GA	304SS sheet .080	3.7500 sf (.125 ea)	100-Waterjet - Flow - 1	3243464

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M304S14GA	4	93	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Jack Saddle	4.468Inches ± 0.010	4.478 4.458	4.474	
2	Jack Saddle	4.114Inches ± 0.010	4.124 4.104	4.112	
3	Jack Saddle	2.933Inches ± 0.010	2.943 2.923	2.937	
4	Jack Saddle	1.535Inches ± 0.010	1.545 1.525	1.540	
5	Jack Saddle	0.354Inches ± 0.010	0.364 0.344	.353	
6	Jack Saddle	0.354Inches ± 0.010	0.364 0.344	.352	
7	Jack Saddle	0.604Inches ± 0.010	0.614 0.594	.603	
8	Jack Saddle	2.000Inches ± 0.010	2.010 1.990	1.998	
9	Jack Saddle	3.396Inches ± 0.010	3.406 3.386	3.401	
10	Jack Saddle	3.646Inches ± 0.010	3.656 3.636	3.645	
11	Jack Saddle	4.000Inches ± 0.010	4.010 3.990	4.006	
12	Jack Saddle	1.525Inches ± 0.010	1.535 1.515	1.534	
13	Jack Saddle	2.475Inches ± 0.010	2.485 2.465	2.481	
14	Jack Saddle	0.323Inches + 0.006 - 0.001	0.329 0.322	0.322	Diameter
15	Jack Saddle	0.080Inches ± 0.010	0.090 0.070	.073	

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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

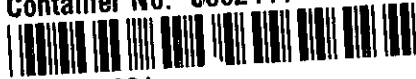
Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor		
			QC / QA Coordinator		
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					



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Container No: S302444



Part: D2281

Job No: 212591

Serial No/Batch: S302444

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

D-2a 09/23/20